

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014716**Date Inspected:** 16-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

West of Bay 14-

Caltrans QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 11AE base metal repair areas of bottom panels, BP186A, BP78A, and BP132A. ZPMC welder was identified as 044772. ZPMC QC was identified as Wang Wei Ming. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-4G(4F)-Repair and ZPMC welding repair report B-WR-12264.

ZPMC personnel performing Magnetic Particle Testing of 11AE deck panel diaphragm, Floor beam to side and bottom panel, and longitudinal diaphragm welds.

Caltrans QA performed preliminary inspection OBG segment 12CW deck panel diaphragm to Floor Beam tack welds at panel point 117. ZPMC has performed Shielded Metal Arc Welding (SMAW) tack welding and Flux Cored Arc Welding (FCAW) between tacks. Below list the amount of tack welds visually inspected and the amount Longitudinal linear indications observed.

PP117

FB3092A- 17 of 28 tack welds with longitudinal linear indications.

WELDING INSPECTION REPORT

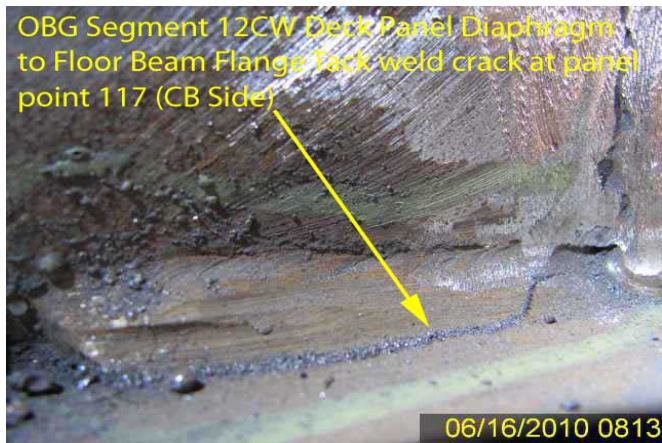
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FB3098A- 6 of 26 tack welds with longitudinal linear indications.

FB3073A- 20 of 29 tack welds with longitudinal linear indications.

Please see the following pictures below for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Viars,Larry

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer